

5/13

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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>22523</b>
<b>Description:</b> STA 84 bracket	<b>Part Number:</b>	<b>D2803-1</b>
<b>Dwg:</b> D2803 rev. <i>10/11/05</i>	<b>Qty:</b>	<b>20</b>

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	<i>JA</i>	05.02.23	20
2	METAL	Cut blanks per template DT8533 Material: 6061-T6 bar 10.00" x 0.50" Batch: <i>M10958 M10627</i>	<i>2</i>	05.03.17	20
3	HAAS	Machine as per folio FA102	<i>Bl.</i>	05/03/22	20
4	QC	Inspect Level 2	<i>Bl.</i>	05/03/22	20
5	QC	Inspect Level 8	<i>Er</i>	05/03/22	20
6	METAL	Tumble & Deburr	<i>Bl.</i>	05/03/22	20
7	QC	Inspect Level 5	<i>Er</i>	05/03/22	20
8	FINISHING	Chemical conversion coat per QSI 005	<i>J.C.</i>	05/03/24	20
9	STORES	Identify and stock	<i>SB</i>	05/03/28	20
10	EXPEDITING	Close W/O Cost / part: <i>59.36</i> <i>59.65</i> <i>500 05/03/29</i> <i>(20)</i>	<i>JA</i>	05.04.05	20

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	<i>EC</i>

RELEASED

*EC* 00.11.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

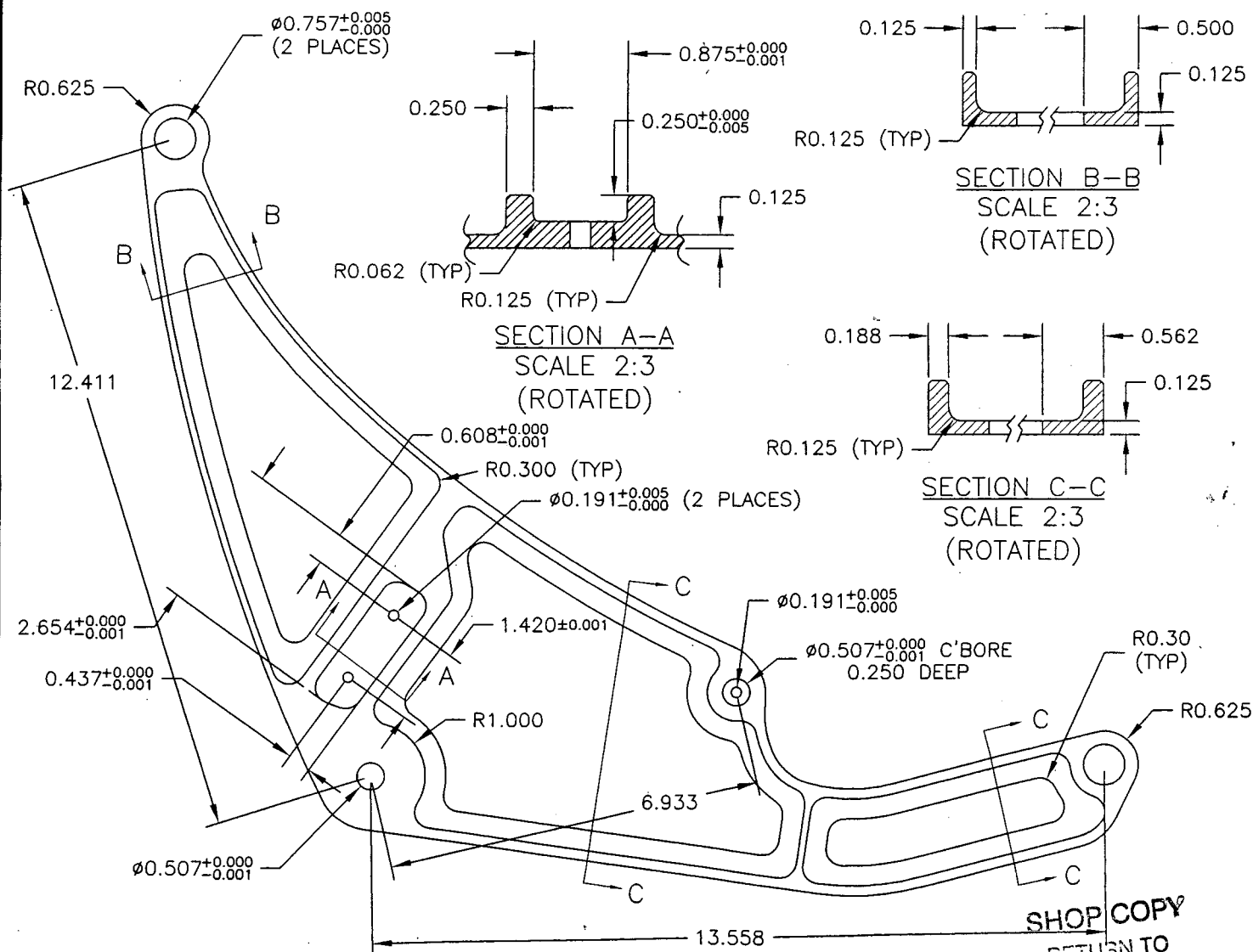
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# PRELIMINARY ISSUE

CP

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	



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## D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER  
NO. 22523

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Feb 22, 2005  
03:39 pm

Work Order No : 0022523  
Project Name : D2803-1  
Project For : WK513  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2803-1  
Description : STA 84 Bracket  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 02-22-05  
Est Finish Date : 03-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 22523
STAG BRACKET		
Description:		Part Number: 02803-1
Inspection Dwg: 02803 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.625	$\pm 0.010$	.621	✓		Vernier	
Ø.757	$\pm 0.005$	.759	✓			
Ø.191	$\pm 0.005$	.192	✓			
Ø.507	$\pm 0.001$	.507	✓		Mic	
13.558	$\pm 0.010$	13.558	✓		Tape	
Ø.507	$\pm 0.001$	.507	✓		Mic	
12.411	$\pm 0.010$	12.411	✓		Tape	
2.654	$\pm 0.001$	2.654	✓		Vernier	
.437	$\pm 0.001$	.437	✓		}	
1.420	$\pm 0.001$	1.419	✓			
6.933	$\pm 0.010$	6.933	✓			
.250	$\pm 0.010$	.251	✓			
.875	$\pm 0.001$	.8744	✓			
.250	$\pm 0.005$	.245	✓		Vernier	
.125	$\pm 0.010$	.130	✓		}	Floor web
.125	$\pm 0.010$	.130	✓			"
.125	$\pm 0.010$	.130	✓			"
.125	$\pm 0.010$	.126	✓			Wall
.500	$\pm 0.010$	.500	✓			
.562	$\pm 0.010$	.562	✓			
.188	$\pm 0.010$	.186	✓			

Measured by: B.G.	Audited by: EP	Prototype Approval: N/A
Date: 05/03/21	Date: 05/03/21	Date:

Rev A	Date:	Change New Issue	Revised by KJ/JLM	Approved
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